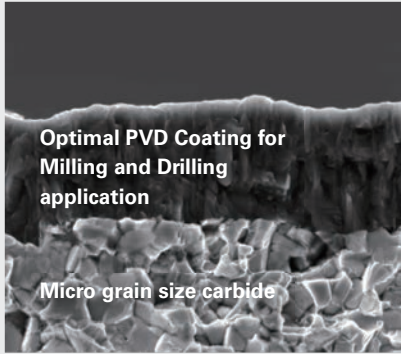


Features of Grades :

YG-1 Universal grades, designs for multi-purpose application and extremely efficient in covering materials including Steels, Stainless Steels and Cast Iron.

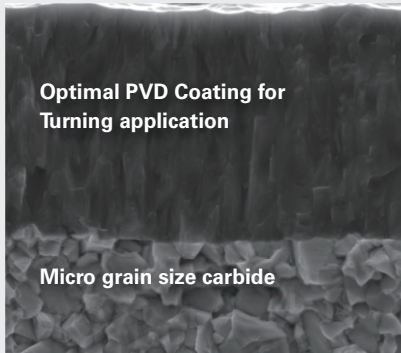
YG602



Exclusive PVD coating / Unique Substrate for MILLING and DRILLING Application

- Ultra dense PVD coating with optimal thermal resistance & added strength
- Sub-micron substrate designed for demanding application

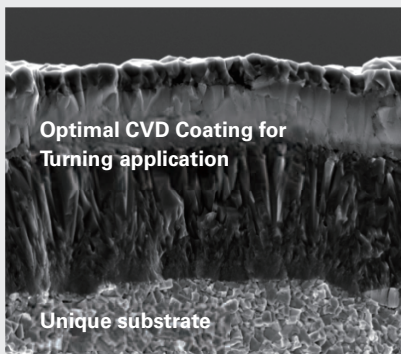
YG801



Exclusive PVD coating / Unique Substrate for TURNING Application

- Unique PVD coating and substrate designed to balance edge strength & wear resistance for continuous machining.
- Excellent cutting performance under harsh machining condition.

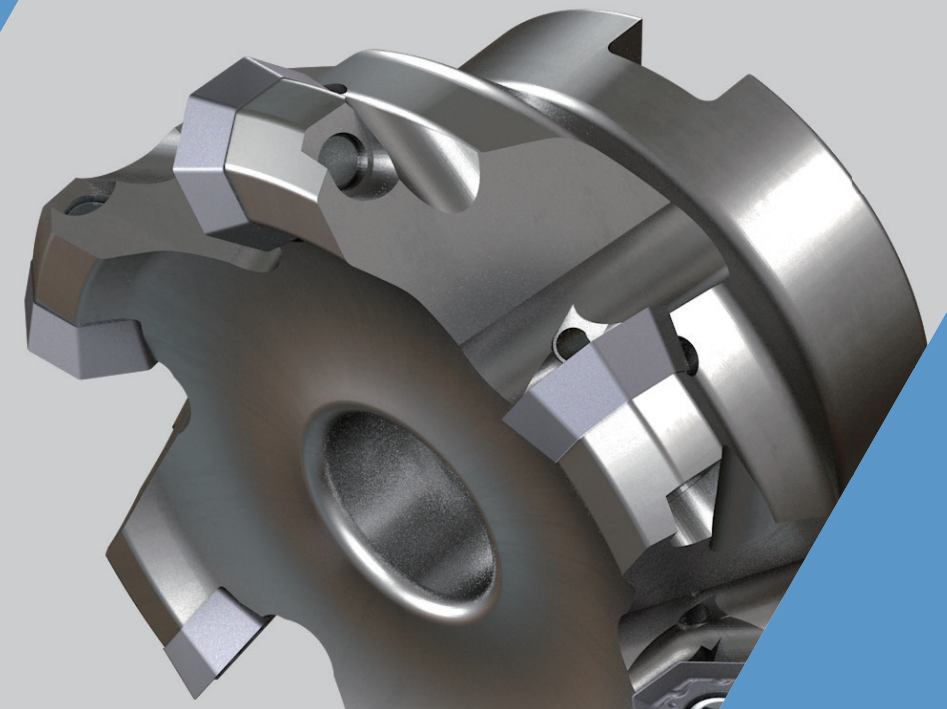
YG1001



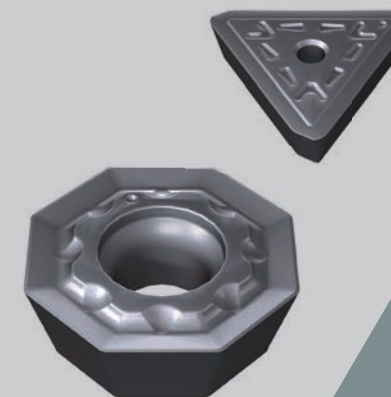
Unique Substrate / CVD coating for TURNING Application

- Thick coating optimized for Cast iron applications and harsh machining condition.
- Advanced CVD coating with optimal thermal & wear resistance for turning applications.
- Exceptional cutting performance attributed to combination of carbide substrate and coating.

Grade	P	M	K	S
YG602	P30-40	M20-30	K20-30	S10-20
YG801	P20-40	M20-40	K10-25	S05-25
YG1001	-	-	K10-25	-



YG MILL
INDEXABLE CUTTING TOOLS
YG UNIVERSAL LINE





1 Insert Shape

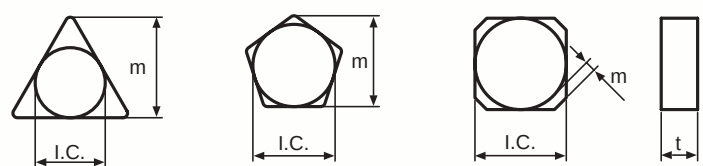
A	B	C	D	E	H	K	L
						Special	
O	P	R	S	T	W	X	

2 Clearance Angle

	5°	7°	15°	20°	25°	30°	0°	11°
	B	C	D	E	F	G	N	P

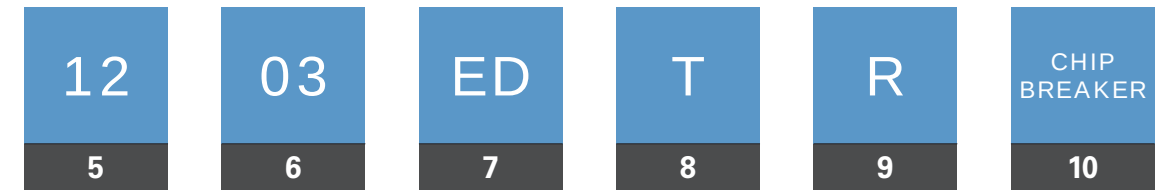
3 Tolerance

	Tolerance			I.C. Size					
	m	t	I.C.	6.35	9.525	12.7	15.875	19.05	25.4
A	± 0.005	± 0.025	± 0.025	●	●	●	●	●	●
C	± 0.013	± 0.025	± 0.025	●	●	●	●	●	●
E	± 0.025	± 0.025	± 0.025	●	●	●	●	●	●
F	± 0.005	± 0.025	± 0.013	●	●	●	●	●	●
G	± 0.025	± 0.13	± 0.025	●	●	●	●	●	●
H	± 0.013	± 0.025	± 0.013	●	●	●	●	●	●
K	± 0.013	± 0.025	± 0.05	●	●				
			± 0.08			●			
			± 0.10				●	●	
			± 0.13						●
M	± 0.08 ± 0.13 ± 0.15 ± 0.18	± 0.13	± 0.05	●	●				
			± 0.08			●			
			± 0.10				●	●	
			± 0.13						●



4 Cross Section Shape

								Special
A	F	G	M	N	R	T	W	X



5 Cutting Edge Length

I.C. Size	C	S	R	T	H	O
Metric						
5.56	05	05	05	09		
6.35	06	06	06	11		
7.94	08	07	07	13		
9.525	09	09	09	16		
12.7	12	12	12	22	05	05
15.875	16	15	15	27	09	06
19.05	19	19	19	33	10	
25.4	25	25	25	44		

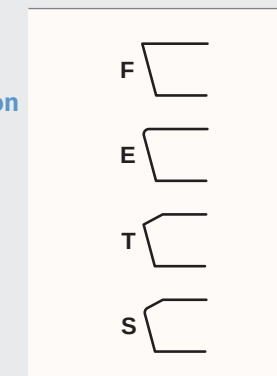
6 Thickness

	t
Symbol(t)	mm
02	2.38
03	3.18
T3	3.97
04	4.76
06	6.35
07	7.94
09	9.52

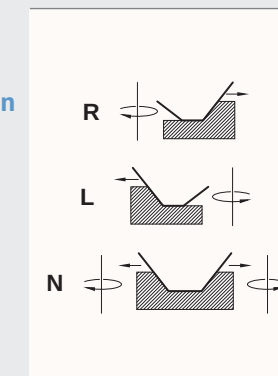
7 Lead Angle & Relief Angle of Minor Cutting Edge

	K
	θ
Lead Angle	
A	45°
D	60°
E	75°
F	85°
P	90°
Z	Special
Relief Angle of minor cutting edge	
B	5°
C	7°
D	15°
E	20°
F	25°
G	30°
N	0°
P	11°
Z	Special

8 Edge Preparation



9 Cutting Direction



10 Chip Breaker

For Application

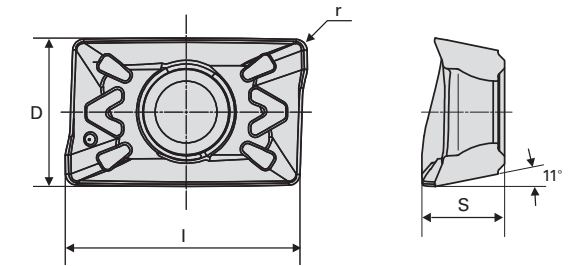
METRIC

Designation	YG	S1	45	-	25	Z2	S	25	P	200	-	12
No.	①	②	③		④	⑤	⑥	⑦	⑧	⑨		⑩

No.	Meaning	Symbol	Explanation
①	Brand Name	YG	YG-1 Global
②	Insert Type	S1	S1-SEKN, S2-SEKT, S3-SEMT...
③	Cutting Degree	45	45, 90 - Cutting degree
④	Tool Diameter	25	Ø20, Ø30... Ø125...
⑤	No. of Teeth	Z2	2, 3, 4... 12...
⑥	Tool Type (Interface)	S	Shank type
		C	Cutter type
		M	Modular type (M08, M10, M12...)
⑦	Shank Diameter	25	Ø25 - Shank diameter
	Coupling Size	32	Ø32 - Cutter coupling size
⑧	Shank Type	P	Plain (Cylindrical shank)
		F	Flat (Weldon shank)
⑨	Tool Length	200	100mm, 150mm, 200mm...
⑩	Insert Size	12	08, 10, 17...

* Additional information(data) will be described in specific dimensions.

APKT 1003



Designation	Grade	Dimensions			
		L	D	S	r
APKT 100305PDTR	YG602	10.58	6.70	3.60	0.5
APKT 100308PDTR	YG602	10.58	6.70	3.60	0.8

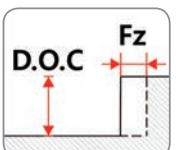


APKT 1003

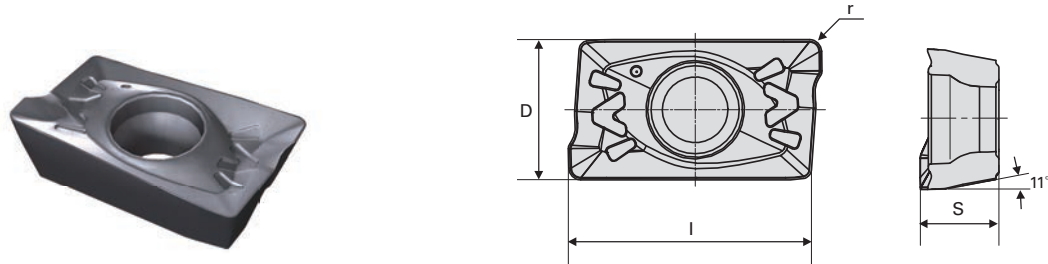
Recommended Cutting Condition

Material			Cutting Conditions								
Group	Sub Group	Hardness (HB)	Feed (mm/tooth)			Vc (m/min.)			Depth Of Cut (mm)		
			Min.	Max.	Recommend	Min.	Max.	Recommend	Min.	Max.	Recommend
P	Non Alloys	120	0.13	0.26	0.20	190	330	250	0.5	9.0	2.0
	Low Alloys	200	0.11	0.21	0.16	150	240	200	0.5	9.0	2.0
	High Alloys	220	0.08	0.18	0.13	90	150	120	0.5	6.4	1.5
M	Austenitic	190	0.11	0.21	0.16	190	250	220	0.5	9.0	2.0
K	Grey Cast Iron	140	0.13	0.26	0.20	150	240	200	0.5	9.0	2.0
S	Heat Resistant and Super Alloys	240	0.08	0.15	0.12	25	45	35	0.5	6.4	1.5
H	Hardened Materials	45HRc	0.07	0.15	0.11	40	80	60	0.5	3.2	1.0

* D.O.C: Depth Of Cut



APKT 1604



Designation	Grade	Dimensions			
		L	D	S	r
APKT 160404PDTR	YG602	16.32	9.40	5.27	0.4
APKT 160408PDTR	YG602	16.32	9.40	5.27	0.8
APKT 160412PDTR	YG602	16.32	9.40	5.27	1.2
APKT 160416PDTR	YG602	16.32	9.40	5.27	1.6

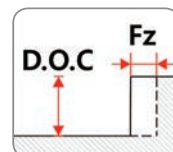


APKT 1604

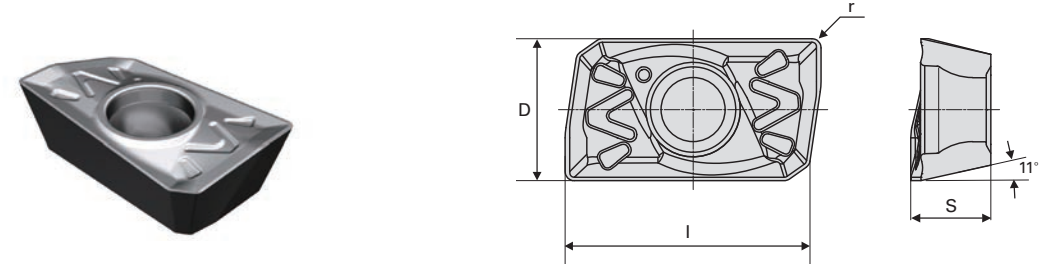
Recommended Cutting Condition

Material			Cutting Conditions								
Group	Sub Group	Hardness (HB)	Feed (mm/tooth)			Vc (m/min.)			Depth Of Cut (mm)		
			Min.	Max.	Recommend	Min.	Max.	Recommend	Min.	Max.	Recommend
P	Non Alloys	120	0.18	0.32	0.25	190	330	250	0.5	15.0	4.0
	Low Alloys	200	0.15	0.25	0.20	150	240	195	0.5	15.0	4.0
	High Alloys	220	0.12	0.22	0.17	90	150	120	0.5	10.7	4.0
M	Austenitic	190	0.15	0.25	0.20	190	250	220	0.5	15.0	3.0
K	Grey Cast Iron	140	0.18	0.32	0.25	150	240	195	0.5	15.0	4.0
S	Heat Resistant and Super Alloys	240	0.12	0.18	0.15	25	45	35	0.5	10.7	3.0
H	Hardened Materials	45HRc	0.10	0.18	0.14	40	80	60	0.5	5.4	2.0

* D.O.C: Depth Of Cut



APMT 1135



Designation	Grade	Dimensions			
		L	D	S	r
APMT 113504PDTR	YG602	10.69	6.20	3.50	0.4
APMT 113508PDTR	YG602	10.69	6.20	3.50	0.8

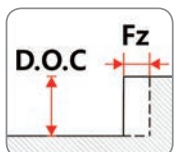


APMT 1135

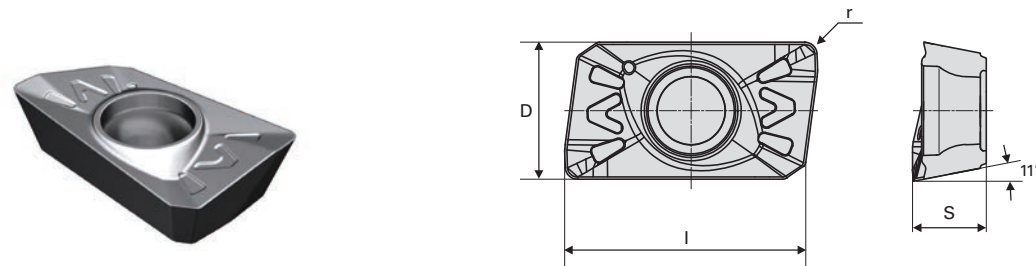
Recommended Cutting Condition

Material			Cutting Conditions								
Group	Sub Group	Hardness (HB)	Feed (mm/tooth)			Vc (m/min.)			Depth Of Cut (mm)		
			Min.	Max.	Recommend	Min.	Max.	Recommend	Min.	Max.	Recommend
P	Non Alloys	120	0.13	0.22	0.18	190	330	250	0.5	10.0	2.0
	Low Alloys	200	0.11	0.18	0.15	150	240	200	0.5	10.0	2.0
	High Alloys	220	0.08	0.15	0.12	90	150	120	0.5	7.2	1.5
M	Austenitic	190	0.11	0.18	0.15	190	250	220	0.5	10.0	2.0
K	Grey Cast Iron	140	0.13	0.22	0.18	150	240	200	0.5	10.0	2.0
S	Heat Resistant and Super Alloys	240	0.08	0.13	0.11	25	45	35	0.5	7.2	1.5
H	Hardened Materials	45HRc	0.07	0.13	0.07	40	80	60	0.5	3.6	1.0

* D.O.C: Depth Of Cut



APMT 1604



Designation	Grade	Dimensions			
		L	D	S	r
APMT 160408PDTR	YG602	16.25	9.22	4.76	0.8

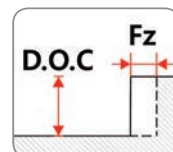


APMT 1604

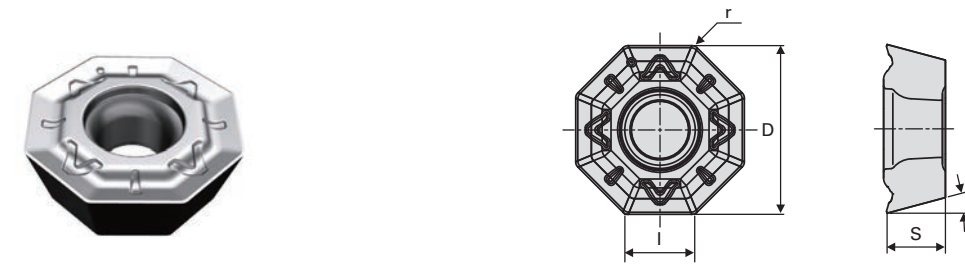
Recommended Cutting Condition

Material			Cutting Conditions								
Group	Sub Group	Hardness (HB)	Feed (mm/tooth)			Vc (m/min.)			Depth Of Cut (mm)		
			Min.	Max.	Recommend	Min.	Max.	Recommend	Min.	Max.	Recommend
P	Non Alloys	120	0.16	0.30	0.23	190	330	250	0.5	15.0	4.0
	Low Alloys	200	0.14	0.23	0.19	150	240	200	0.5	15.0	4.0
	High Alloys	220	0.11	0.2	0.16	90	150	120	0.5	10.7	4.0
M	Austenitic	190	0.14	0.23	0.19	190	250	220	0.5	15.0	4.0
K	Grey Cast Iron	140	0.16	0.30	0.23	150	240	200	0.5	15.0	4.0
S	Heat Resistant and Super Alloys	240	0.11	0.17	0.14	25	45	35	0.5	10.7	3.0
H	Hardened Materials	45HRc	0.09	0.17	0.13	40	80	60	0.5	5.4	2.0

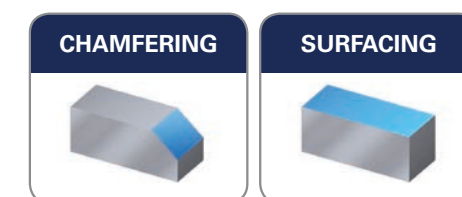
* D.O.C: Depth Of Cut



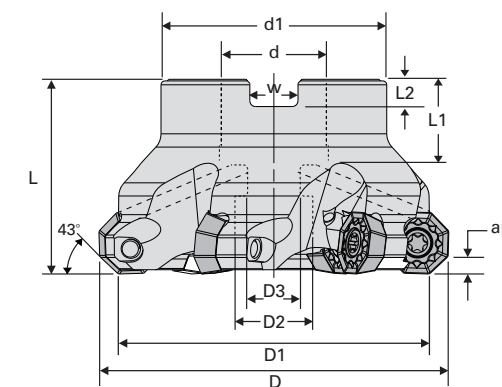
ODMT 0605



Designation	Grade	Dimensions			
		L	D	S	r
ODMT 060508	YG602	6.60	15.88	5.50	0.8



ODMT 0605 / Cutter



Designation	Dimensions												
	D	D1	D2	D3	d	d1	w	L	L1	L2	ap	z	Coolant
YGO143-63Z5C22-06	73	63	18	11	22	50	10.4	40	20	6.3	3.5	5	Y
YGO143-80Z6C27-06	90	80	20	13.5	27	58	12.4	50	22	7	3.5	6	Y
YGO143-100Z7C32-06	110	100	26.5	17.5	32	78	14.4	50	25	8	3.5	7	Y
YGO143-125Z8C40-06	135	125	32.5	22.5	40	90	16.4	63	29	9	3.5	8	Y

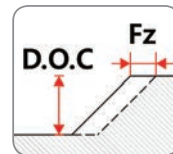
Insert	Spare parts	
	Screw	Wrench
ODMT(W) 06	TP205013	TPWFTP20

ODMT 0605

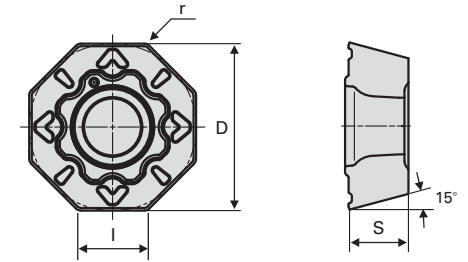
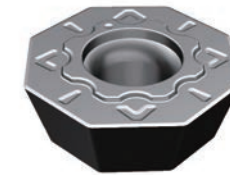
Recommended Cutting Condition

Material			Cutting Conditions								
Group	Sub Group	Hardness (HB)	Feed (mm/tooth)			Vc (m/min.)			Depth Of Cut (mm)		
			Min.	Max.	Recommend	Min.	Max.	Recommend	Min.	Max.	Recommend
P	Non Alloys	120	0.22	0.54	0.38	190	330	250	0.5	4.0	2.5
	Low Alloys	200	0.18	0.43	0.31	150	240	195	0.5	4.0	2.5
	High Alloys	220	0.14	0.37	0.26	90	150	120	0.5	2.9	1.9
M	Austenitic	190	0.18	0.37	0.28	190	250	220	0.5	4.0	2.5
K	Grey Cast Iron	140	0.22	0.54	0.38	150	240	195	0.5	4.0	2.5
S	Heat Resistant and Super Alloys	240	0.14	0.31	0.23	25	45	35	0.5	2.9	1.9
H	Hardened Materials	45HRc	0.12	0.31	0.22	40	80	60	0.4	1.4	1.3

* D.O.C: Depth Of Cut

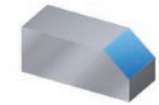


ODMW 0605

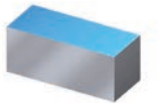


Designation	Grade	Dimensions			
		I	D	S	r
ODMW 060508	YG602	6.60	15.88	5.50	0.8

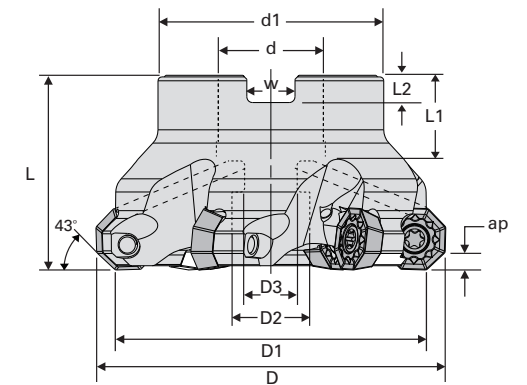
CHAMFERING



SURFACING



ODMW 0605 / Cutter



Designation	Dimensions												
	D	D1	D2	D3	d	d1	w	L	L1	L2	ap	z	Coolant
YGO143-63Z5C22-06	73	63	18	11	22	50	10.4	40	20	6.3	3.5	5	Y
YGO143-80Z6C27-06	90	80	20	13.5	27	58	12.4	50	22	7	3.5	6	Y
YGO143-100Z7C32-06	110	100	26.5	17.5	32	78	14.4	50	25	8	3.5	7	Y
YGO143-125Z8C40-06	135	125	32.5	22.5	40	90	16.4	63	29	9	3.5	8	Y

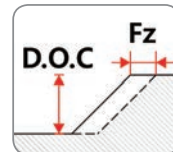
Insert	Spare parts	
	Screw	Wrench
ODMT(W) 06	TP205013	TPWFTP20

ODMW 0605

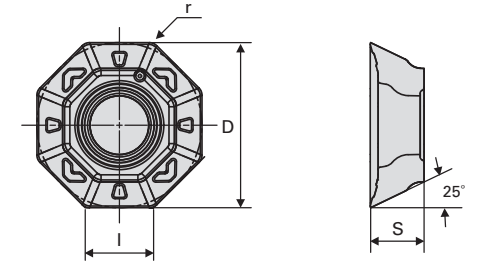
Recommended Cutting Condition

Material			Cutting Conditions								
Group	Sub Group	Hardness (HB)	Feed (mm/tooth)			Vc (m/min.)			Depth Of Cut (mm)		
			Min.	Max.	Recommend	Min.	Max.	Recommend	Min.	Max.	Recommend
P	Non Alloys	120	0.22	0.58	0.40	190	330	250	0.5	4.0	3.0
	Low Alloys	200	0.18	0.45	0.32	150	240	195	0.5	4.0	3.0
	High Alloys	220	0.14	0.40	0.27	90	150	120	0.5	2.9	2.3
K	Grey Cast Iron	140	0.22	0.58	0.40	150	240	195	0.5	4.0	3.0
H	Hardened Materials	45HRc	0.12	0.32	0.22	40	80	60	0.4	1.4	1.3

* D.O.C: Depth Of Cut

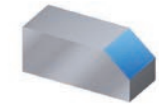


OFMT 05T3

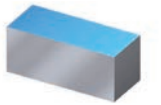


Designation	Grade	Dimensions			
		I	D	S	r
OFMT 05T308	YG602	5.27	12.70	4.02	0.8

CHAMFERING



SURFACING

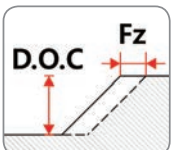


OFMT 05T3

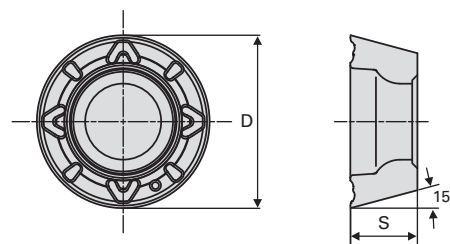
Recommended Cutting Condition

Material			Cutting Conditions								
Group	Sub Group	Hardness (HB)	Feed (mm/tooth)			Vc (m/min.)			Depth Of Cut (mm)		
			Min.	Max.	Recommend	Min.	Max.	Recommend	Min.	Max.	Recommend
P	Non Alloys	120	0.22	0.51	0.37	190	330	250	0.5	3.5	2.5
	Low Alloys	200	0.18	0.40	0.29	150	240	195	0.5	3.5	2.5
	High Alloys	220	0.14	0.35	0.25	90	150	120	0.5	2.5	1.9
M	Austenitic	190	0.18	0.35	0.27	190	250	220	0.5	3.5	2.5
K	Grey Cast Iron	140	0.22	0.51	0.37	150	240	195	0.5	3.5	2.5
S	Heat Resistant and Super Alloys	240	0.14	0.29	0.22	25	45	35	0.5	2.5	1.9
H	Hardened Materials	45HRc	0.12	0.29	0.21	40	80	60	0.4	1.3	1.3

* D.O.C: Depth Of Cut



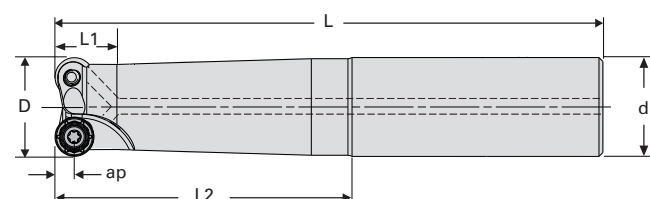
RDKT 0802



Designation	Grade	Dimensions			
		I	D	S	r
RDKT 0802M0	YG602	-	8.00	2.38	-

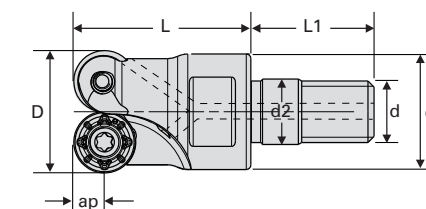


RDKT 0802 / Shank



Designation	Dimensions								Insert	Spare parts	
	D	d	L1	L2	L	z	ap	Shank		Screw	Wrench
YGR1-16Z2S16P160-08	16	16	12	60	160	2	4	Plain	Y	RDKT(W) 08	
YGR1-20Z2S20P180-08	20	20	12	80	180	2	4	Plain	Y	RDKT(W) 08	TP082505
YGR1-25Z3S20P180-08	25	20	-	40	180	3	4	Plain	Y	RDKT(W) 08	TPWFTP08

RDKT 0802 / Modular



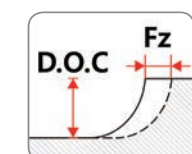
Designation	Dimensions								Insert	Spare parts	
	D	d	d1	d2	L	L1	z	ap		Screw	Wrench
YGR1-16Z2M08-08	16	M8	13	8.5	23	16	2	4	Y	RDKT(W) 08	
YGR1-20Z2M10-08	20	M10	18	10.5	30	18	2	4	Y	RDKT(W) 08	TP082505
YGR1-25Z3M12-08	25	M12	21	12.5	35	20	3	4	Y	RDKT(W) 08	TPWFTP08

RDKT 0802

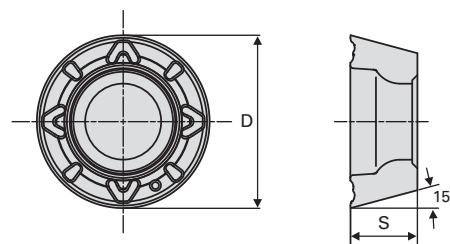
Recommended Cutting Condition

Material			Cutting Conditions								
Group	Sub Group	Hardness (HB)	Feed (mm/tooth)			Vc (m/min.)			Depth Of Cut (mm)		
			Min.	Max.	Recommend	Min.	Max.	Recommend	Min.	Max.	Recommend
P	Non Alloys	120	0.18	0.64	0.35	190	330	250	0.5	2.5	0.8
	Low Alloys	200	0.15	0.50	0.30	150	240	195	0.5	2.5	0.8
	High Alloys	220	0.12	0.44	0.25	90	150	120	0.5	1.8	0.6
M	Austenitic	190	0.15	0.50	0.30	190	250	220	0.5	2.5	0.8
K	Grey Cast Iron	140	0.18	0.64	0.35	150	240	195	0.5	2.5	0.8
S	Heat Resistant and Super Alloys	240	0.12	0.32	0.24	25	45	35	0.5	1.5	0.6
H	Hardened Materials	45HRc	0.10	0.32	0.23	40	80	60	0.3	0.7	0.4

* D.O.C: Depth Of Cut



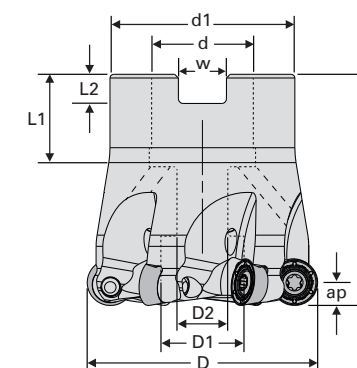
RDKT 10T3



Designation	Grade	Dimensions			
		I	D	S	r
RDKT 10T3M0	YG602	-	10.00	3.97	-



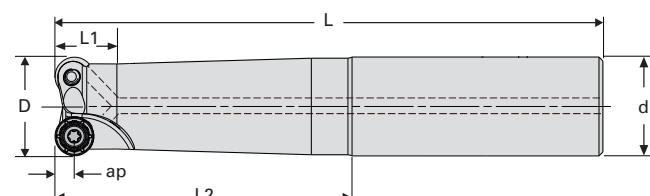
RDKT 10T3 / Cutter



Designation	Dimensions											
	D	D1	D2	d	d1	w	L	L1	L2	ap	z	Coolant
YGR1-40Z5C16-10	40	14	9	16	32	8.4	40	18	5.6	2.5	5	Y
YGR1-50Z6C22-10	50	18	11	22	40	10.4	50	20	6.3	2.5	6	Y

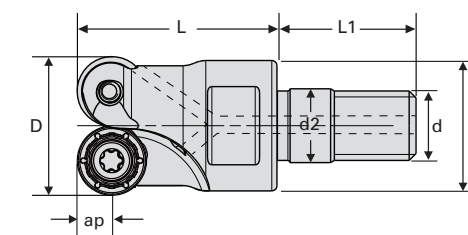
Insert	Spare parts	
	Screw	Wrench
RDKT(W) 10	TP154808	TPWFTP15

RDKT 10T3 / Shank



Designation	Dimensions									Insert	Spare parts	
	D	d	L1	L2	L	z	ap	Shank	Coolant		Screw	Wrench
YGR1-20Z2S20P180-10	20	20	15	80	180	2	5	Plain	Y	RDKT(W) 10	TP154808	TPWFTP15
YGR1-25Z2S25P180-10	25	25	15	80	180	2	5	Plain	Y	RDKT(W) 10		

RDKT 10T3 / Modular



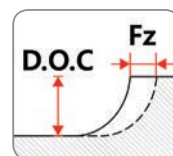
Designation	Dimensions									Insert	Spare parts	
	D	d	d1	d2	L	L1	z	ap	Coolant		Screw	Wrench
YGR1-20Z2M10-10	20	M10	18	10.5	30	18	2	5	Y	RDKT(W) 10	TP154808	TPWFTP15
YGR1-25Z3M12-10	25	M12	21	12.5	35	20	3	5	Y	RDKT(W) 10		

RDKT 10T3

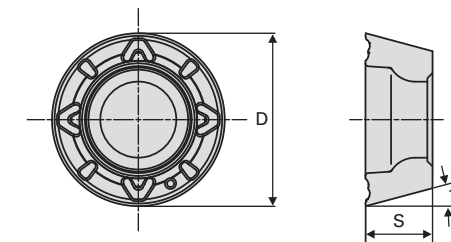
Recommended Cutting Condition

Material			Cutting Conditions								
Group	Sub Group	Hardness (HB)	Feed (mm/tooth)			Vc (m/min.)			Depth Of Cut (mm)		
			Min.	Max.	Recommend	Min.	Max.	Recommend	Min.	Max.	Recommend
P	Non Alloys	120	0.18	0.64	0.35	190	330	250	0.5	2.5	1.0
	Low Alloys	200	0.15	0.50	0.30	150	240	200	0.5	2.5	1.0
	High Alloys	220	0.12	0.44	0.25	90	150	120	0.5	1.8	0.8
M	Austenitic	190	0.15	0.50	0.30	190	250	220	0.5	2.5	1.0
K	Grey Cast Iron	140	0.18	0.64	0.35	150	240	200	0.5	2.5	1.0
S	Heat Resistant and Super Alloys	240	0.12	0.36	0.24	25	45	35	0.5	2.0	0.5
H	Hardened Materials	45HRc	0.10	0.36	0.23	40	80	60	0.3	0.9	0.5

* D.O.C: Depth Of Cut



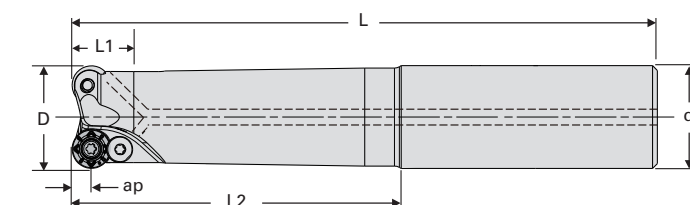
RDKT 1204



Designation	Grade	Dimensions			
		I	D	S	r
RDKT 1204M0	YG602	-	12.00	4.76	-

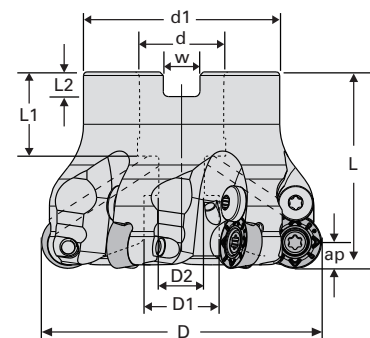


RDKT 1204 / Shank



Designation	Dimensions										Insert	Spare parts	
	D	d	L1	L2	L	z	ap	Shank	Coolant			Screw	Wrench
YGR1-25Z2S25P180-12	25	25	18	80	180	2	6	Plain	Y		RDKT(W) 12	TP154009 + TP153507	TPWFTP15
YGR1-32Z2S32P200-12	32	32	18	100	200	2	6	Plain	Y		RDKT(W) 12		
YGR1-32Z3S32P160-12	32	32	18	60	160	3	6	Plain	Y		RDKT(W) 12		

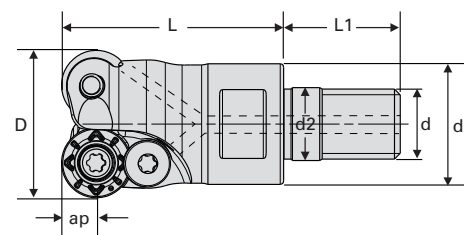
RDKT 1204 / Cutter



Designation	Dimensions											Coolant
	D	D1	D2	d	d1	w	L	L1	L2	ap	z	
YGR1-40Z4C16-12	40	13.8	9	16	32	8.4	40	18	5.6	4	4	Y
YGR1-50Z5C22-12	50	18	11	22	40	10.4	50	20	6.3	4	5	Y
YGR1-63Z6C22-12	63	18	11	22	48	10.4	50	20	6.3	4	6	Y

Insert	Spare parts	
	Screw	Wrench
RDKT(W) 12	TP154009 + TP153507	TPWFTP15

RDKT 1204 / Modular



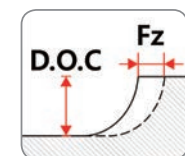
Designation	Dimensions									Insert	Spare parts	
	D	d	d1	d2	L	L1	z	ap	Coolant		Screw	Wrench
YGR1-25Z2M12-12	25	M12	21	12.5	35	20	2	6	Y	RDKT(W) 12	TP154009 + TP153507	TPWFTP15
YGR1-32Z3M16-12	32	M16	29	17	42	22	3	6	Y	RDKT(W) 12	TP154009 + TP153507	TPWFTP15

RDKT 1204

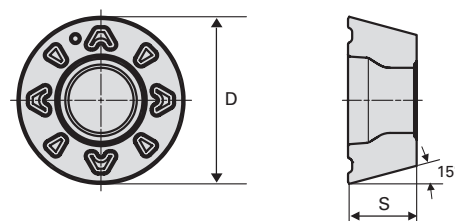
Recommended Cutting Condition

Material			Cutting Conditions								
Group	Sub Group	Hardness (HB)	Feed (mm/tooth)			Vc (m/min.)			Depth Of Cut (mm)		
			Min.	Max.	Recommend	Min.	Max.	Recommend	Min.	Max.	Recommend
P	Non Alloys	120	0.18	0.64	0.35	190	330	250	0.5	2.5	1.3
	Low Alloys	200	0.15	0.50	0.30	150	240	200	0.5	2.5	1.3
	High Alloys	220	0.12	0.44	0.25	90	150	120	0.5	1.8	1.0
M	Austenitic	190	0.15	0.50	0.30	190	250	220	0.5	2.5	1.3
K	Grey Cast Iron	140	0.18	0.64	0.35	150	240	200	0.5	2.5	1.3
S	Heat Resistant and Super Alloys	240	0.17	0.41	0.29	25	45	35	0.5	2.4	1.0
H	Hardened Materials	45HRc	0.14	0.41	0.28	40	80	60	0.3	1.1	0.7

* D.O.C: Depth Of Cut



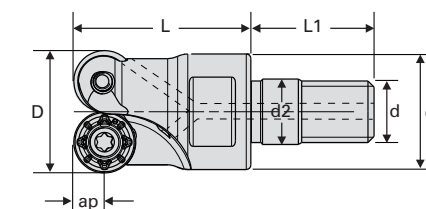
RDKW 0802



Designation	Grade	Dimensions			
		I	D	S	r
RDKW 0802M0	YG602	-	8.00	2.38	-

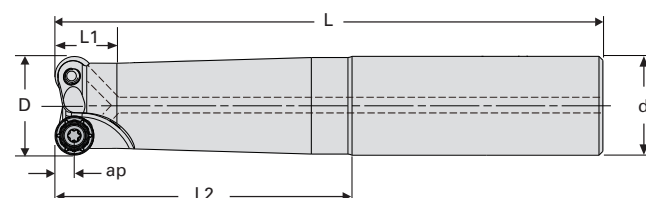


RDKW 0802 / Modular



Designation	Dimensions									Insert	Spare parts	
	D	d	d1	d2	L	L1	z	ap	Coolant		Screw	Wrench
YGR1-16Z2M08-08	16	M8	13	8.5	23	16	2	4	Y	RDKT(W) 08	TP082505	TPWFTP08
YGR1-20Z2M10-08	20	M10	18	10.5	30	18	2	4	Y	RDKT(W) 08		
YGR1-25Z3M12-08	25	M12	21	12.5	35	20	3	4	Y	RDKT(W) 08		

RDKW 0802 / Shank



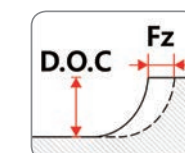
Designation	Dimensions									Insert	Spare parts	
	D	d	L1	L2	L	z	ap	Shank	Coolant		Screw	Wrench
YGR1-16Z2S16P160-08	16	16	12	60	160	2	4	Plain	Y	RDKT(W) 08	TP082505	TPWFTP08
YGR1-20Z2S20P180-08	20	20	12	80	180	2	4	Plain	Y	RDKT(W) 08		
YGR1-25Z3S20P180-08	25	20	-	40	180	3	4	Plain	Y	RDKT(W) 08		

RDKW 0802

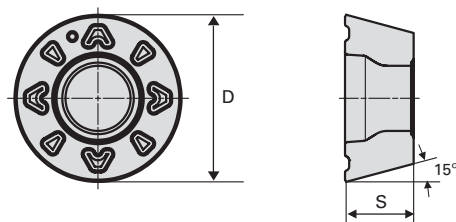
Recommended Cutting Condition

Material			Cutting Conditions								
Group	Sub Group	Hardness (HB)	Feed (mm/tooth)			Vc (m/min.)			Depth Of Cut (mm)		
			Min.	Max.	Recommend	Min.	Max.	Recommend	Min.	Max.	Recommend
P	Non Alloys	120	0.18	0.64	0.41	190	330	260	0.5	2.5	0.8
	Low Alloys	200	0.15	0.50	0.33	150	240	195	0.5	2.5	0.8
	High Alloys	220	0.12	0.44	0.28	90	150	120	0.5	1.8	0.6
K	Grey Cast Iron	140	0.18	0.64	0.35	150	240	195	0.5	2.5	0.8
H	Hardened Materials	45HRc	0.10	0.32	0.23	40	80	60	0.3	0.7	0.4

* D.O.C: Depth Of Cut



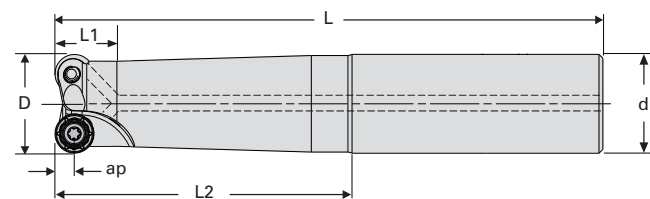
RDKW 10T3



Designation	Grade	Dimensions			
		I	D	S	r
RDKW 10T3M0	YG602	-	10.00	3.97	-

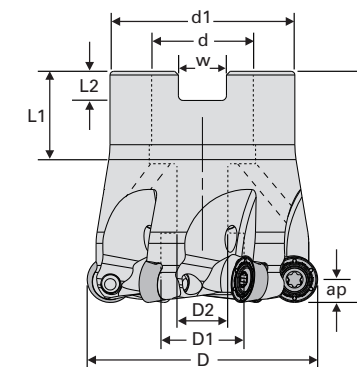


RDKW 10T3 / Shank



Designation	Dimensions									Insert	Spare parts	
	D	d	L1	L2	L	z	ap	Shank	Coolant		Screw	Wrench
YGR1-20Z2S20P180-10	20	20	15	80	180	2	5	Plain	Y	RDKT(W) 10	TP154808	TPWFTP15
YGR1-25Z2S25P180-10	25	25	15	80	180	2	5	Plain	Y	RDKT(W) 10		

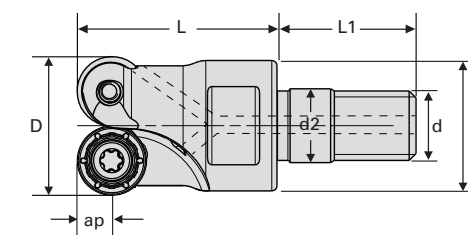
RDKW 10T3 / Cutter



Designation	Dimensions											
	D	D1	D2	d	d1	w	L	L1	L2	ap	z	Coolant
YGR1-40Z5C16-10	40	14	9	16	32	8.4	40	18	5.6	2.5	5	Y
YGR1-50Z6C22-10	50	18	11	22	40	10.4	50	20	6.3	2.5	6	Y

Insert	Spare parts	
	Screw	Wrench
RDKT(W) 10	TP154808	TPWFTP15

RDKW 10T3 / Modular



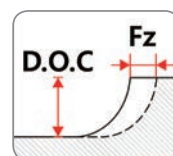
Designation	Dimensions									Insert	Spare parts	
	D	d	d1	d2	L	L1	z	ap	Coolant		Screw	Wrench
YGR1-20Z2M10-10	20	M10	18	10.5	30	18	2	5	Y	RDKT(W) 10	TP154808	TPWFTP15
YGR1-25Z3M12-10	25	M12	21	12.5	35	20	3	5	Y	RDKT(W) 10		

RDKW 10T3

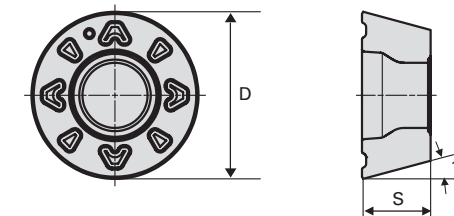
Recommended Cutting Condition

Material			Cutting Conditions								
Group	Sub Group	Hardness (HB)	Feed (mm/tooth)			Vc (m/min.)			Depth Of Cut (mm)		
			Min.	Max.	Recommend	Min.	Max.	Recommend	Min.	Max.	Recommend
P	Non Alloys	120	0.18	0.64	0.35	190	330	250	0.5	2.5	1.0
	Low Alloys	200	0.15	0.50	0.30	150	240	200	0.5	2.5	1.0
	High Alloys	220	0.12	0.44	0.25	90	150	120	0.5	1.8	0.8
K	Grey Cast Iron	140	0.18	0.64	0.35	150	240	200	0.5	2.5	1.0
H	Hardened Materials	45HRc	0.10	0.36	0.23	40	80	60	0.3	0.9	0.5

* D.O.C: Depth Of Cut



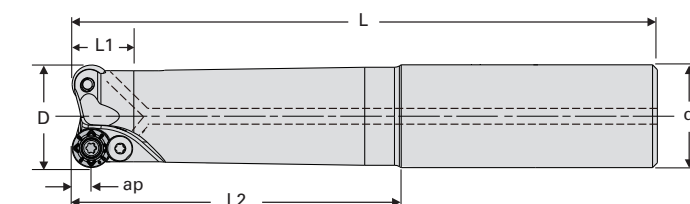
RDKW 1204



Designation	Grade	Dimensions			
		I	D	S	r
RDKW 1204M0	YG602	-	12.00	4.76	-

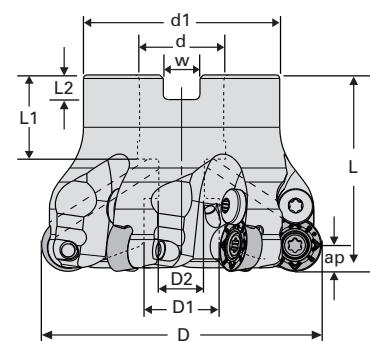


RDKW 1204 / Shank



Designation	Dimensions										Insert	Spare parts	
	D	d	L1	L2	L	z	ap	Shank	Coolant			Screw	Wrench
YGR1-25Z2S25P180-12	25	25	18	80	180	2	6	Plain	Y		RDKT(W) 12	TP154009 + TP153507	TPWFTP15
YGR1-32Z2S32P200-12	32	32	18	100	200	2	6	Plain	Y		RDKT(W) 12		
YGR1-32Z3S32P160-12	32	32	18	60	160	3	6	Plain	Y		RDKT(W) 12		

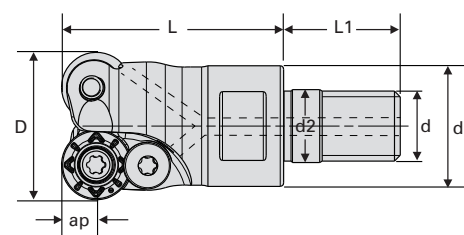
RDKW 1204 / Cutter



Designation	Dimensions											Coolant
	D	D1	D2	d	d1	w	L	L1	L2	ap	z	
YGR1-40Z4C16-12	40	13.8	9	16	32	8.4	40	18	5.6	4	4	Y
YGR1-50Z5C22-12	50	18	11	22	40	10.4	50	20	6.3	4	5	Y
YGR1-63Z6C22-12	63	18	11	22	48	10.4	50	20	6.3	4	6	Y

Insert	Spare parts	
	Screw	Wrench
RDKT(W) 12	TP154009 + TP153507	TPWFTP15

RDKW 1204 / Modular



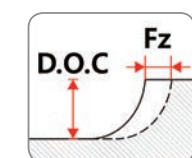
Designation	Dimensions									Insert	Spare parts	
	D	d	d1	d2	L	L1	z	ap	Coolant		Screw	Wrench
YGR1-25Z2M12-12	25	M12	21	12.5	35	20	2	6	Y	RDKT(W) 12	TP154009 + TP153507	TPWFTP15
YGR1-32Z3M16-12	32	M16	29	17	42	22	3	6	Y	RDKT(W) 12	TP154009 + TP153507	TPWFTP15

RDKW 1204

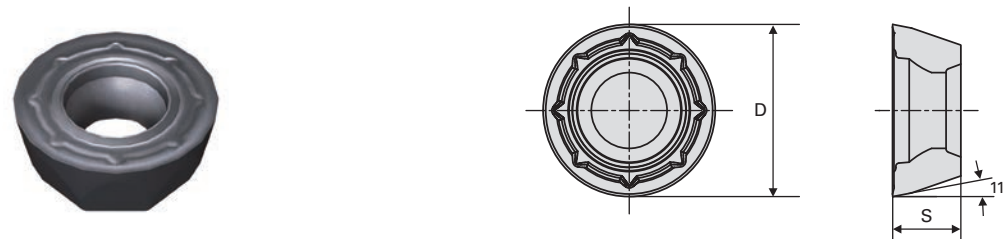
Recommended Cutting Condition

Material			Cutting Conditions								
Group	Sub Group	Hardness (HB)	Feed (mm/tooth)			Vc (m/min.)			Depth Of Cut (mm)		
			Min.	Max.	Recommend	Min.	Max.	Recommend	Min.	Max.	Recommend
P	Non Alloys	120	0.18	0.64	0.35	190	330	250	0.5	2.5	1.3
	Low Alloys	200	0.15	0.50	0.30	150	240	200	0.5	2.5	1.3
	High Alloys	220	0.12	0.44	0.25	90	150	120	0.5	1.8	1.0
K	Grey Cast Iron	140	0.18	0.64	0.35	150	240	200	0.5	2.5	1.3
H	Hardened Materials	45HRc	0.14	0.41	0.28	40	80	60	0.3	1.1	0.7

* D.O.C: Depth Of Cut



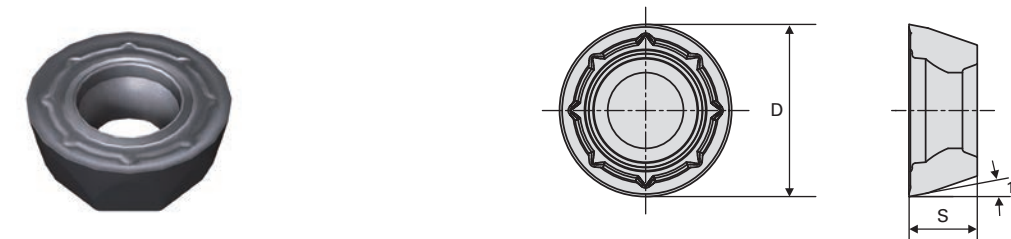
RPMT 08T2



Designation	Grade	Dimensions			
		I	D	S	r
RPMT 08T2M0	YG602	-	8.00	2.76	-



RPMT 10T3



Designation	Grade	Dimensions			
		I	D	S	r
RPMT 10T3M0	YG602	-	10.00	3.96	-

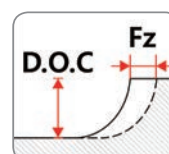


RPMT 08T2

Recommended Cutting Condition

Material			Cutting Conditions								
Group	Sub Group	Hardness (HB)	Feed (mm/tooth)			Vc (m/min.)			Depth Of Cut (mm)		
			Min.	Max.	Recommend	Min.	Max.	Recommend	Min.	Max.	Recommend
P	Non Alloys	120	0.18	0.64	0.41	190	330	250	0.5	2.5	0.8
	Low Alloys	200	0.15	0.50	0.33	150	240	195	0.5	2.5	0.8
	High Alloys	220	0.12	0.44	0.28	90	150	120	0.5	1.8	0.6
M	Austenitic	190	0.15	0.50	0.33	190	250	220	0.5	2.5	0.8
K	Grey Cast Iron	140	0.18	0.64	0.41	150	240	195	0.5	2.5	0.8
S	Heat Resistant and Super Alloys	240	0.12	0.32	0.22	25	45	35	0.5	1.5	0.6
H	Hardened Materials	45HRc	0.10	0.32	0.21	40	80	60	0.3	0.7	0.4

* D.O.C: Depth Of Cut

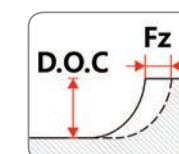


RPMT 10T3

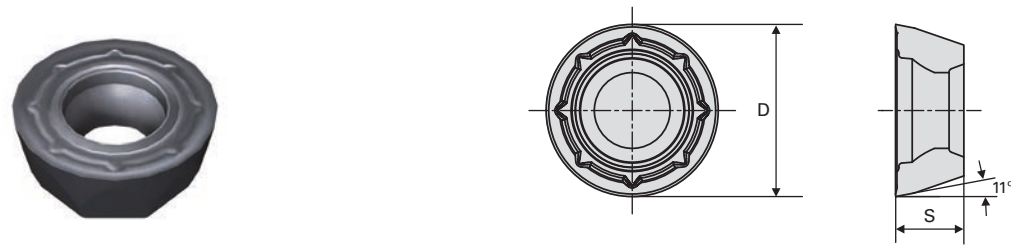
Recommended Cutting Condition

Material			Cutting Conditions								
Group	Sub Group	Hardness (HB)	Feed (mm/tooth)			Vc (m/min.)			Depth Of Cut (mm)		
			Min.	Max.	Recommend	Min.	Max.	Recommend	Min.	Max.	Recommend
P	Non Alloys	120	0.18	0.64	0.35	190	330	250	0.5	2.5	1.0
	Low Alloys	200	0.15	0.50	0.30	150	240	200	0.5	2.5	1.0
	High Alloys	220	0.12	0.44	0.25	90	150	120	0.5	1.8	0.8
M	Austenitic	190	0.15	0.50	0.30	190	250	220	0.5	2.5	1.0
K	Grey Cast Iron	140	0.18	0.64	0.35	150	240	200	0.5	2.5	1.0
S	Heat Resistant and Super Alloys	240	0.12	0.36	0.24	25	45	35	0.5	2.0	0.8
H	Hardened Materials	45HRc	0.10	0.36	0.23	40	80	60	0.3	0.9	0.5

* D.O.C: Depth Of Cut



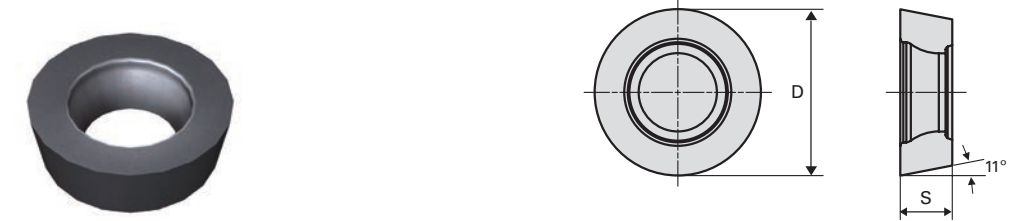
RPMT 1204



Designation	Grade	Dimensions			
		I	D	S	r
RPMT 1204M0	YG602	-	12.00	4.74	-



RPMW 1204



Designation	Grade	Dimensions			
		I	D	S	r
RPMW 1204M0	YG602	-	12.00	4.71	-

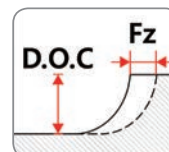


RPMT 1204

Recommended Cutting Condition

Material			Cutting Conditions								
Group	Sub Group	Hardness (HB)	Feed (mm/tooth)			Vc (m/min.)			Depth Of Cut (mm)		
			Min.	Max.	Recommend	Min.	Max.	Recommend	Min.	Max.	Recommend
P	Non Alloys	120	0.18	0.64	0.35	190	330	250	0.5	2.5	1.3
	Low Alloys	200	0.15	0.50	0.30	150	240	195	0.5	2.5	1.3
	High Alloys	220	0.12	0.44	0.25	90	150	120	0.5	1.8	1.0
M	Austenitic	190	0.15	0.50	0.30	190	250	220	0.5	2.5	1.3
K	Grey Cast Iron	140	0.18	0.64	0.35	150	240	195	0.5	2.5	1.3
S	Heat Resistant and Super Alloys	240	0.13	0.30	0.29	25	50	38	0.5	2.4	1.5
H	Hardened Materials	45HRc	0.50	0.22	0.28	50	100	75	0.5	1.9	1.8

* D.O.C: Depth Of Cut

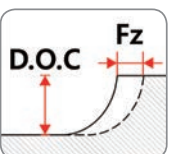


RPMW 1204

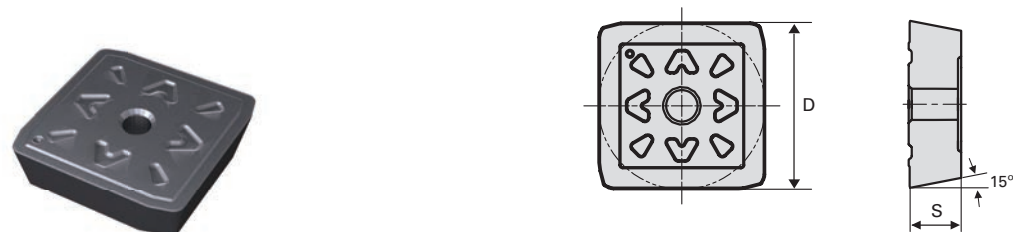
Recommended Cutting Condition

Material			Cutting Conditions								
Group	Sub Group	Hardness (HB)	Feed (mm/tooth)			Vc (m/min.)			Depth Of Cut (mm)		
			Min.	Max.	Recommend	Min.	Max.	Recommend	Min.	Max.	Recommend
P	Non Alloys	120	0.18	0.64	0.35	190	330	250	0.5	2.5	1.3
	Low Alloys	200	0.15	0.50	0.30	150	240	200	0.5	2.5	1.3
	High Alloys	220	0.12	0.44	0.25	90	150	120	0.5	1.8	1.0
K	Grey Cast Iron	140	0.18	0.64	0.35	150	240	200	0.5	2.5	1.3
H	Hardened Materials	45HRc	0.14	0.41	0.28	40	80	60	0.3	1.1	0.7

* D.O.C: Depth Of Cut



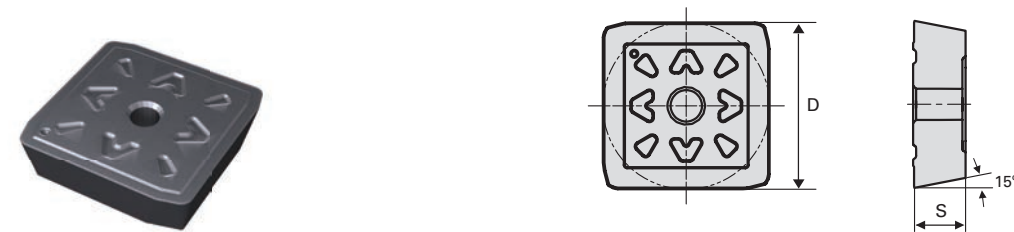
SDKN 1203



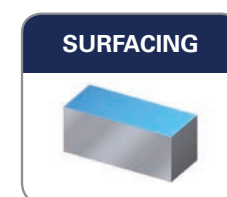
Designation	Grade	Dimensions			
		I	D	S	r
SDKN 1203AETN	YG602	-	12.70	3.18	-



SDKN 1504



Designation	Grade	Dimensions			
		I	D	S	r
SDKN 1504AETN	YG602	-	15.88	4.76	-

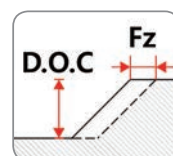


SDKN 1203

Recommended Cutting Condition

Material			Cutting Conditions								
Group	Sub Group	Hardness (HB)	Feed (mm/tooth)			Vc (m/min.)			Depth Of Cut (mm)		
			Min.	Max.	Recommend	Min.	Max.	Recommend	Min.	Max.	Recommend
P	Non Alloys	120	0.18	0.46	0.32	190	330	250	0.5	7.0	3.0
	Low Alloys	200	0.15	0.36	0.26	150	240	195	0.5	7.0	3.0
	High Alloys	220	0.12	0.32	0.22	90	150	120	0.5	5.0	2.3
K	Grey Cast Iron	140	0.18	0.46	0.32	150	240	195	0.5	7.0	3.0
H	Hardened Materials	45HRc	0.10	0.24	0.17	40	80	60	0.5	2.5	1.5

* D.O.C: Depth Of Cut

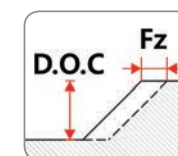


SDKN 1504

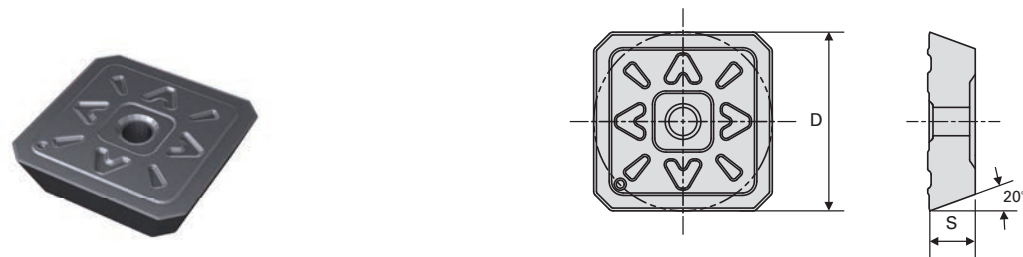
Recommended Cutting Condition

Material			Cutting Conditions								
Group	Sub Group	Hardness (HB)	Feed (mm/tooth)			Vc (m/min.)			Depth Of Cut (mm)		
			Min.	Max.	Recommend	Min.	Max.	Recommend	Min.	Max.	Recommend
P	Non Alloys	120	0.18	0.43	0.31	190	330	250	0.5	9.0	4.0
	Low Alloys	200	0.15	0.34	0.25	150	240	195	0.5	9.0	4.0
	High Alloys	220	0.12	0.30	0.21	90	150	120	0.5	6.5	3.0
K	Grey Cast Iron	140	0.18	0.43	0.31	150	240	195	0.5	9.0	4.0
H	Hardened Materials	45HRc	0.10	0.24	0.17	40	80	60	0.5	3.2	2.0

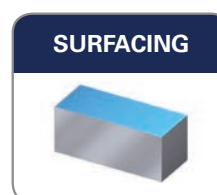
* D.O.C: Depth Of Cut



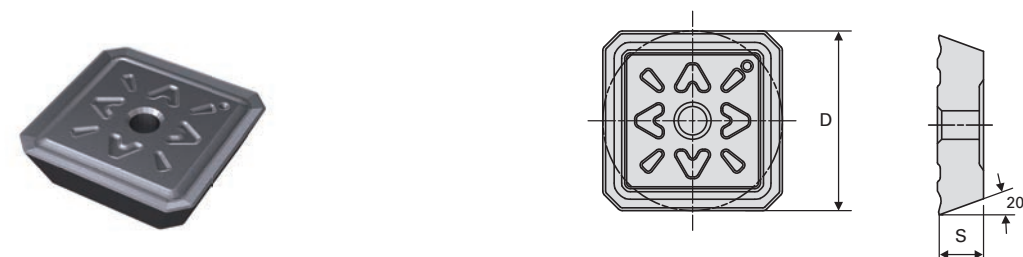
SEKN 1203



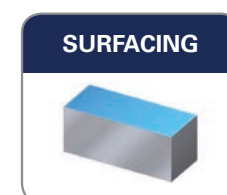
Designation	Grade	Dimensions			
		I	D	S	r
SEKN 1203AFTN	YG602	-	12.70	3.18	-



SEKR 1203



Designation	Grade	Dimensions			
		I	D	S	r
SEKR 1203AFTN	YG602	-	12.70	3.18	-

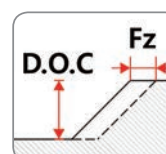


SEKN 1203

Recommended Cutting Condition

Material			Cutting Conditions								
Group	Sub Group	Hardness (HB)	Feed (mm/tooth)			Vc (m/min.)			Depth Of Cut (mm)		
			Min.	Max.	Recommend	Min.	Max.	Recommend	Min.	Max.	Recommend
P	Non Alloys	120	0.18	0.46	0.32	190	330	250	0.5	7.0	3.0
	Low Alloys	200	0.15	0.36	0.26	150	240	195	0.5	7.0	3.0
	High Alloys	220	0.12	0.32	0.22	90	150	120	0.5	5.0	2.3
M	Austenitic	190	0.15	0.32	0.24	190	250	220	0.5	7.0	3.0
K	Grey Cast Iron	140	0.18	0.46	0.32	150	240	195	0.5	7.0	3.0
S	Heat Resistant and Super Alloys	240	0.10	0.26	0.18	25	45	35	0.5	5.0	2.3
H	Hardened Materials	45HRc	0.10	0.26	0.18	40	80	60	0.5	2.5	1.0

* D.O.C: Depth Of Cut

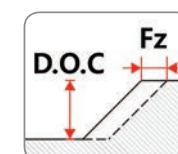


SEKR 1203

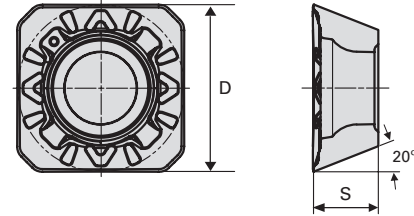
Recommended Cutting Condition

Material			Cutting Conditions								
Group	Sub Group	Hardness (HB)	Feed (mm/tooth)			Vc (m/min.)			Depth Of Cut (mm)		
			Min.	Max.	Recommend	Min.	Max.	Recommend	Min.	Max.	Recommend
P	Non Alloys	120	0.18	0.46	0.32	190	330	250	0.5	7.0	3.0
	Low Alloys	200	0.15	0.36	0.26	150	240	195	0.5	7.0	3.0
	High Alloys	220	0.12	0.32	0.22	90	150	120	0.5	5.0	2.3
M	Austenitic	190	0.15	0.32	0.24	190	250	220	0.5	7.0	3.0
K	Grey Cast Iron	140	0.18	0.46	0.32	150	240	195	0.5	7.0	3.0
S	Heat Resistant and Super Alloys	240	0.12	0.26	0.19	25	45	35	0.5	5.0	2.3
H	Hardened Materials	45HRc	0.10	0.26	0.18	40	80	60	0.5	2.5	1.5

* D.O.C: Depth Of Cut

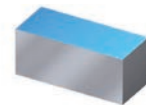


SEKT 1204

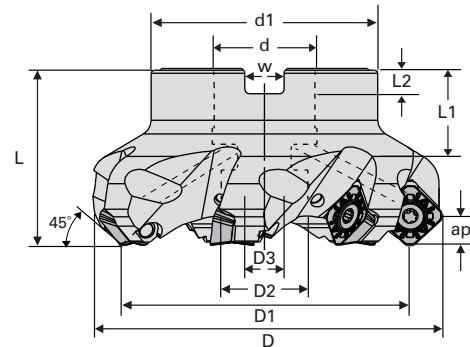


Designation	Grade	Dimensions			
		I	D	S	r
SEKT 1204AFTN	YG602	-	12.73	4.94	-

SURFACING



SEKT 1204 / Cutter



Designation	Dimensions												
	D	D1	D2	D3	d	d1	w	L	L1	L2	ap	z	Coolant
YGS145-40Z4C16-12	53.6	40	14	9	16	32	8.4	40	18	5.6	6	4	Y
YGS145-50Z5C22-12	63.4	50	18	11	22	48	10.4	40	20	6.3	6	5	Y
YGS145-63Z4C22-12	76.2	63	18	11	22	50	10.4	40	20	6.3	6	4	Y
YGS145-63Z6C22-12	76.2	63	18	11	22	50	10.4	40	20	6.3	6	6	Y
YGS145-80Z4C27-12	93.4	80	20	13.5	27	56	12.4	50	22	7	6	4	Y
YGS145-80Z7C27-12	93.4	80	20	13.5	27	56	12.4	50	22	7	6	7	Y
YGS145-100Z8C32-12	113.5	100	26.5	17.5	32	78	14.4	50	25	8	6	8	Y
YGS145-125Z10C40-12	138.5	125	32.5	22.5	40	90	16.4	63	29	9	6	10	Y
YGS145-160Z12C40-12	173.6	160	-	-	40	114	16.4	63	30	9	6	12	N

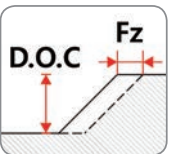
Insert	Spare parts	
	Screw	Wrench
SEKT1204	TP204510	TPWFTP20

SEKT 1204

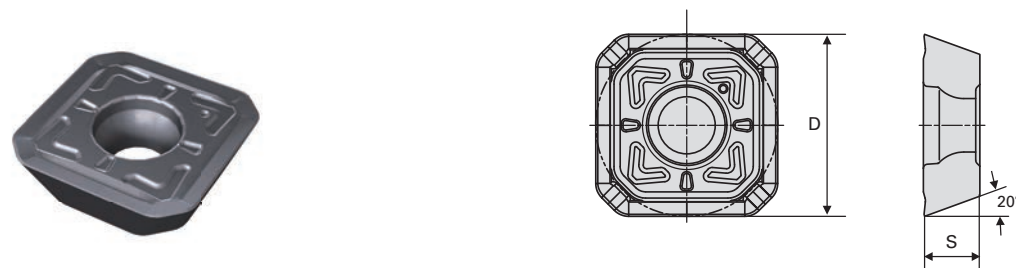
Recommended Cutting Condition

Material			Cutting Conditions								
Group	Sub Group	Hardness (HB)	Feed (mm/tooth)			Vc (m/min.)			Depth Of Cut (mm)		
			Min.	Max.	Recommend	Min.	Max.	Recommend	Min.	Max.	Recommend
P	Non Alloys	120	0.18	0.46	0.30	190	330	250	0.5	7.0	3.0
	Low Alloys	200	0.15	0.36	0.25	150	240	200	0.5	7.0	3.0
	High Alloys	220	0.12	0.32	0.22	90	150	120	0.5	5.0	2.0
M	Austenitic	190	0.15	0.32	0.25	190	250	220	0.5	7.0	3.0
K	Grey Cast Iron	140	0.18	0.46	0.30	150	240	200	0.5	7.0	3.0
S	Heat Resistant and Super Alloys	240	0.12	0.26	0.19	25	45	35	0.5	5.0	2.3
H	Hardened Materials	45HRc	0.10	0.26	0.18	40	80	60	0.5	2.5	1.5

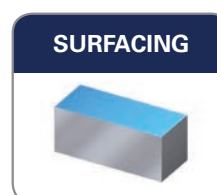
* D.O.C: Depth Of Cut



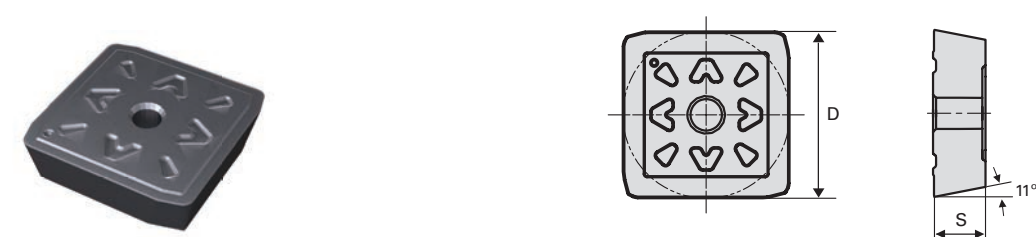
SEKT 12T3



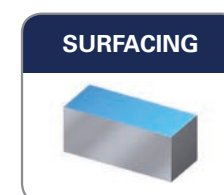
Designation	Grade	Dimensions			
		I	D	S	r
SEKT 12T3AGTN	YG602	-	13.40	3.97	-



SPKN 1203



Designation	Grade	Dimensions			
		I	D	S	r
SPKN 1203EDTR	YG602	-	12.70	3.18	-

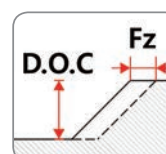


SEKT 12T3

Recommended Cutting Condition

Material			Cutting Conditions								
Group	Sub Group	Hardness (HB)	Feed (mm/tooth)			Vc (m/min.)			Depth Of Cut (mm)		
			Min.	Max.	Recommend	Min.	Max.	Recommend	Min.	Max.	Recommend
P	Non Alloys	120	0.18	0.46	0.30	190	330	250	0.5	7.0	3.0
	Low Alloys	200	0.15	0.36	0.25	150	240	200	0.5	7.0	3.0
	High Alloys	220	0.12	0.32	0.22	90	150	120	0.5	5.0	2.0
M	Austenitic	190	0.15	0.32	0.25	190	250	220	0.5	7.0	3.0
K	Grey Cast Iron	140	0.18	0.46	0.30	150	240	200	0.5	7.0	3.0
S	Heat Resistant and Super Alloys	240	0.12	0.26	0.19	25	45	35	0.5	5.0	2.3
H	Hardened Materials	45HRc	0.10	0.26	0.18	40	80	60	0.5	2.5	1.5

* D.O.C: Depth Of Cut

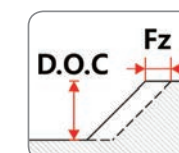


SPKN 1203

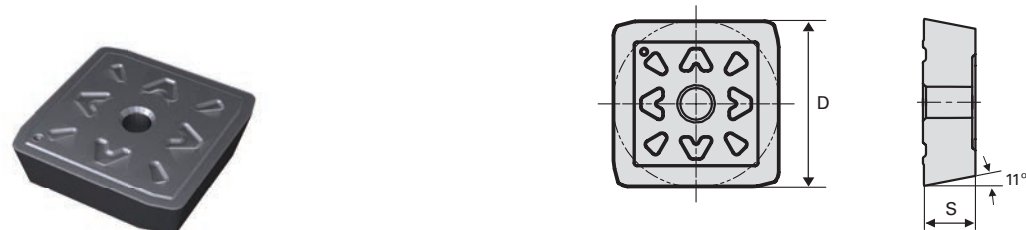
Recommended Cutting Condition

Material			Cutting Conditions								
Group	Sub Group	Hardness (HB)	Feed (mm/tooth)			Vc (m/min.)			Depth Of Cut (mm)		
			Min.	Max.	Recommend	Min.	Max.	Recommend	Min.	Max.	Recommend
P	Non Alloys	120	0.18	0.43	0.30	190	330	250	0.5	7.0	3.0
	Low Alloys	200	0.15	0.34	0.25	150	240	200	0.5	7.0	3.0
	High Alloys	220	0.12	0.30	0.20	90	150	120	0.5	5.0	2.5
K	Grey Cast Iron	140	0.18	0.43	0.30	150	240	200	0.5	7.0	3.0
H	Hardened Materials	45HRc	0.10	0.24	0.17	40	80	60	0.5	2.5	1.5

* D.O.C: Depth Of Cut



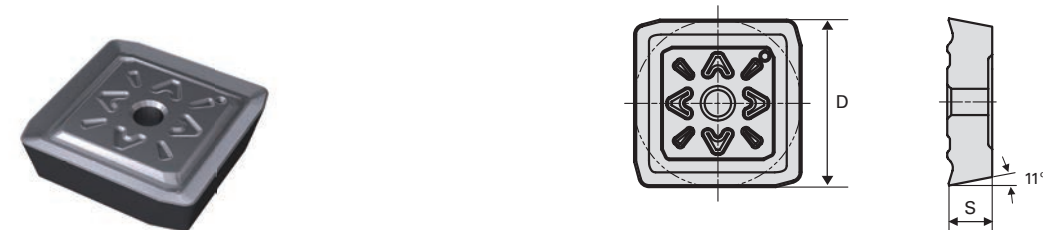
SPKN 1504



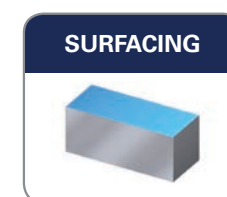
Designation	Grade	Dimensions			
		I	D	S	r
SPKN 1504EDTR	YG602	-	15.88	4.76	-



SPKR 1203



Designation	Grade	Dimensions			
		I	D	S	r
SPKR 1203EDTR	YG602	-	12.70	3.18	-

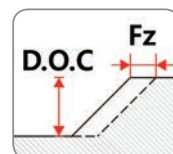


SPKN 1504

Recommended Cutting Condition

Material			Cutting Conditions								
Group	Sub Group	Hardness (HB)	Feed (mm/tooth)			Vc (m/min.)			Depth Of Cut (mm)		
			Min.	Max.	Recommend	Min.	Max.	Recommend	Min.	Max.	Recommend
P	Non Alloys	120	0.18	0.43	0.31	190	330	260	0.5	9.0	4.0
	Low Alloys	200	0.15	0.34	0.25	150	240	195	0.5	9.0	4.0
	High Alloys	220	0.12	0.30	0.21	90	150	120	0.5	6.5	3.0
K	Grey Cast Iron	140	0.18	0.43	0.31	150	240	195	0.5	9.0	4.0
H	Hardened Materials	45HRc	0.10	0.24	0.17	40	80	60	0.5	3.2	2.0

* D.O.C: Depth Of Cut

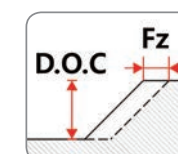


SPKR 1203

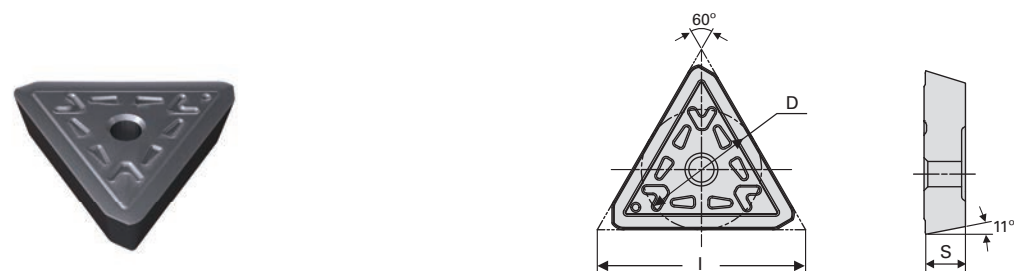
Recommended Cutting Condition

Material			Cutting Conditions								
Group	Sub Group	Hardness (HB)	Feed (mm/tooth)			Vc (m/min.)			Depth Of Cut (mm)		
			Min.	Max.	Recommend	Min.	Max.	Recommend	Min.	Max.	Recommend
P	Non Alloys	120	0.18	0.38	0.25	190	330	250	0.5	7.0	3.0
	Low Alloys	200	0.15	0.30	0.20	150	240	200	0.5	7.0	3.0
	High Alloys	220	0.12	0.26	0.17	90	150	120	0.5	5.0	2.5
M	Austenitic	190	0.15	0.26	0.20	190	250	220	0.5	7.0	3.0
K	Grey Cast Iron	140	0.18	0.38	0.30	150	240	200	0.5	7.0	3.0
S	Heat Resistant and Super Alloys	240	0.12	0.22	0.17	25	45	35	0.5	5.0	2.3
H	Hardened Materials	45HRc	0.10	0.22	0.16	40	80	60	0.5	2.5	1.5

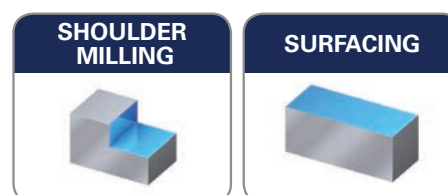
* D.O.C: Depth Of Cut



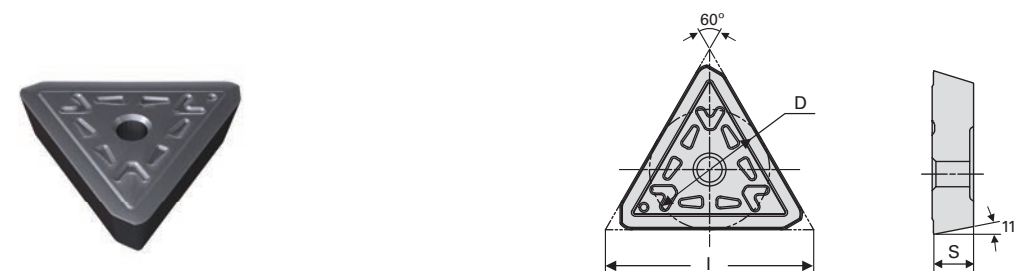
TPKN 1603



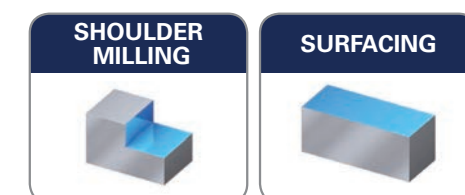
Designation	Grade	Dimensions			
		L	D	S	r
TPKN 1603PDTR	YG602	16.5	9.53	3.14	-



TPKN 2204



Designation	Grade	Dimensions			
		L	D	S	r
TPKN 2204PDTR	YG602	22.0	12.70	4.76	-

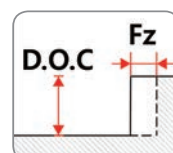


TPKN 1603

Recommended Cutting Condition

Material			Cutting Conditions								
Group	Sub Group	Hardness (HB)	Feed (mm/tooth)			Vc (m/min.)			Depth Of Cut (mm)		
			Min.	Max.	Recommend	Min.	Max.	Recommend	Min.	Max.	Recommend
P	Non Alloys	120	0.14	0.27	0.21	190	330	260	0.5	12.0	3.0
	Low Alloys	200	0.12	0.21	0.17	150	240	195	0.5	12.0	3.0
	High Alloys	220	0.10	0.19	0.15	90	150	120	0.5	8.6	2.5
K	Grey Cast Iron	140	0.14	0.27	0.21	150	240	195	0.5	12.0	3.0
H	Hardened Materials	45HRc	0.08	0.15	0.12	40	80	60	0.5	4.3	1.5

* D.O.C: Depth Of Cut

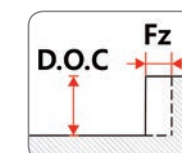


TPKN 2204

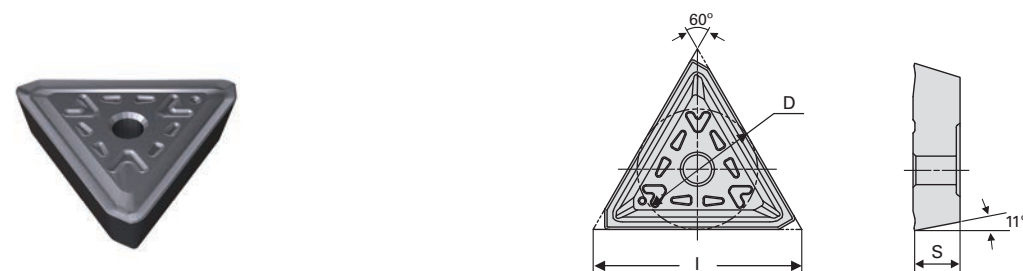
Recommended Cutting Condition

Material			Cutting Conditions								
Group	Sub Group	Hardness (HB)	Feed (mm/tooth)			Vc (m/min.)			Depth Of Cut (mm)		
			Min.	Max.	Recommend	Min.	Max.	Recommend	Min.	Max.	Recommend
P	Non Alloys	120	0.16	0.27	0.22	190	330	260	0.5	18.0	4.0
	Low Alloys	200	0.14	0.21	0.18	150	240	195	0.5	18.0	4.0
	High Alloys	220	0.11	0.19	0.15	90	150	120	0.5	12.9	3.0
K	Grey Cast Iron	140	0.16	0.27	0.22	150	240	195	0.5	18.0	4.0
H	Hardened Materials	45HRc	0.09	0.15	0.12	40	80	60	0.5	6.4	2.0

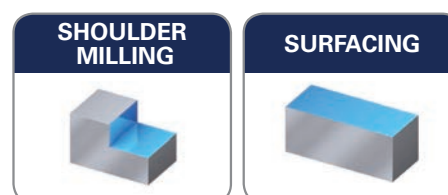
* D.O.C: Depth Of Cut



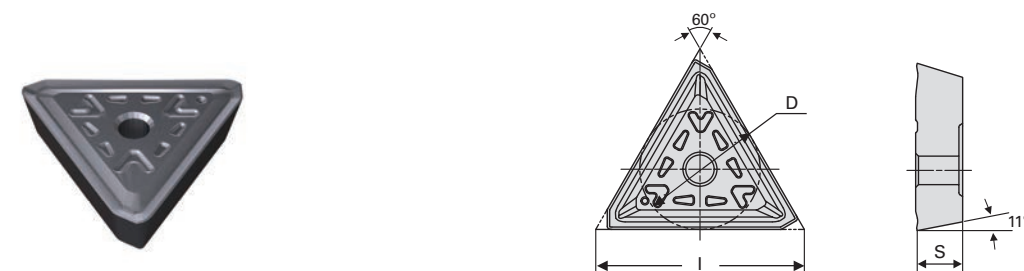
TPKR 1603



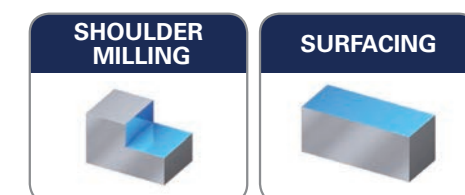
Designation	Grade	Dimensions			
		L	D	S	r
TPKR 1603PDTR	YG602	16.5	9.53	3.14	-



TPKR 2204



Designation	Grade	Dimensions			
		L	D	S	r
TPKR 2204PDTR	YG602	22.0	12.70	4.76	-

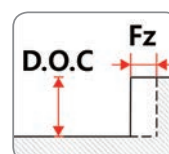


TPKR 1603

Recommended Cutting Condition

Material			Cutting Conditions								
Group	Sub Group	Hardness (HB)	Feed (mm/tooth)			Vc (m/min.)			Depth Of Cut (mm)		
			Min.	Max.	Recommend	Min.	Max.	Recommend	Min.	Max.	Recommend
P	Non Alloys	120	0.16	0.22	0.19	190	330	260	0.5	12.0	3.0
	Low Alloys	200	0.14	0.18	0.16	150	240	195	0.5	12.0	3.0
	High Alloys	220	0.11	0.15	0.13	90	150	120	0.5	8.6	2.5
M	Austenitic	190	0.14	0.15	0.15	190	250	220	0.5	12.0	3.0
K	Grey Cast Iron	140	0.16	0.22	0.19	150	240	195	0.5	12.0	3.0
S	Heat Resistant and Super Alloys	240	0.11	0.13	0.12	25	45	35	0.5	8.6	2.3
H	Hardened Materials	45HRc	0.09	0.13	0.11	40	80	60	0.5	3.4	1.5

* D.O.C: Depth Of Cut



TPKR 2204

Recommended Cutting Condition

Material			Cutting Conditions								
Group	Sub Group	Hardness (HB)	Feed (mm/tooth)			Vc (m/min.)			Depth Of Cut (mm)		
			Min.	Max.	Recommend	Min.	Max.	Recommend	Min.	Max.	Recommend
P	Non Alloys	120	0.16	0.22	0.19	190	330	260	0.5	18.0	4.0
	Low Alloys	200	0.14	0.18	0.16	150	240	195	0.5	18.0	4.0
	High Alloys	220	0.11	0.15	0.13	90	150	120	0.5	12.9	3.0
M	Austenitic	190	0.14	0.15	0.15	190	250	220	0.5	18.0	4.0
K	Grey Cast Iron	140	0.16	0.22	0.19	150	240	195	0.5	18.0	4.0
S	Heat Resistant and Super Alloys	240	0.11	0.13	0.12	25	45	35	0.5	12.9	3.0
H	Hardened Materials	45HRc	0.09	0.13	0.11	40	80	60	0.5	6.4	2.0

* D.O.C: Depth Of Cut

